

Date: Friday, 9/7/2007 10:14:53 AM
 User: Kim Johnston

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HINGE BRACKET |
| Job Number : 34464 | |
| Estimate Number : 10224 | |
| P.O. Number : <u>N/A</u> | Part Number : D2143 |
| This Issue : 9/7/2007 S.O. No. : <u>N/A</u> | Drawing Number : D2143 REV. C1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <u>N/A</u> Type : SMALL /MED FAB | Drawing Revision : C1 |
| Previous Run : 33882 | Material : <u>N/A</u> |
| Written By : <u>JA 07.09.07</u> | Due Date : 9/14/2007 Qty: 20 Um: Each |
| Checked & Approved By : <u>JA 07.09.07</u> | |
| Comment : Est C 06:05.18 Added inspection level 8 EC | |
| Est Rev:D Now on WaterJet 06-10-15 JLM | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0693 sf(s)/Unit Total : 1.3860 sf(s)

Material: 5052-H32-(QQ-A-250/8) 0.040" thick

(M5052H32S.040)

Batch: M101875

SAD 07/09/09 (20)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2143

Dwg Rev: C1Prog Rev: C1

2-Deburr if necessary

SAD 07/09/09 (20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/09 (20)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 07/09/10
 count
 x 20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

SA 07/09/10 (20)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/10/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:14:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 34464

Part Number: D2143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SB 08/01/07 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/07 (+20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-01-11 (20)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

91 08-01-14 (20)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS 08/01/15 (20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST16

AS 08/01/15 x(20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/16 (20)

Job Completion



U 08-01-15

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

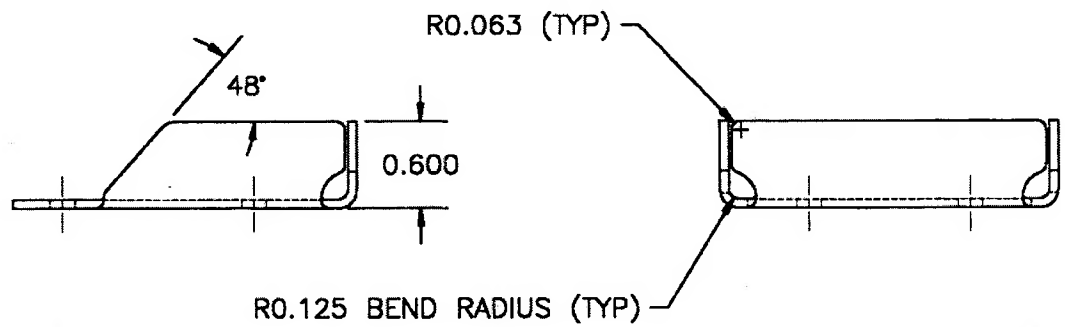
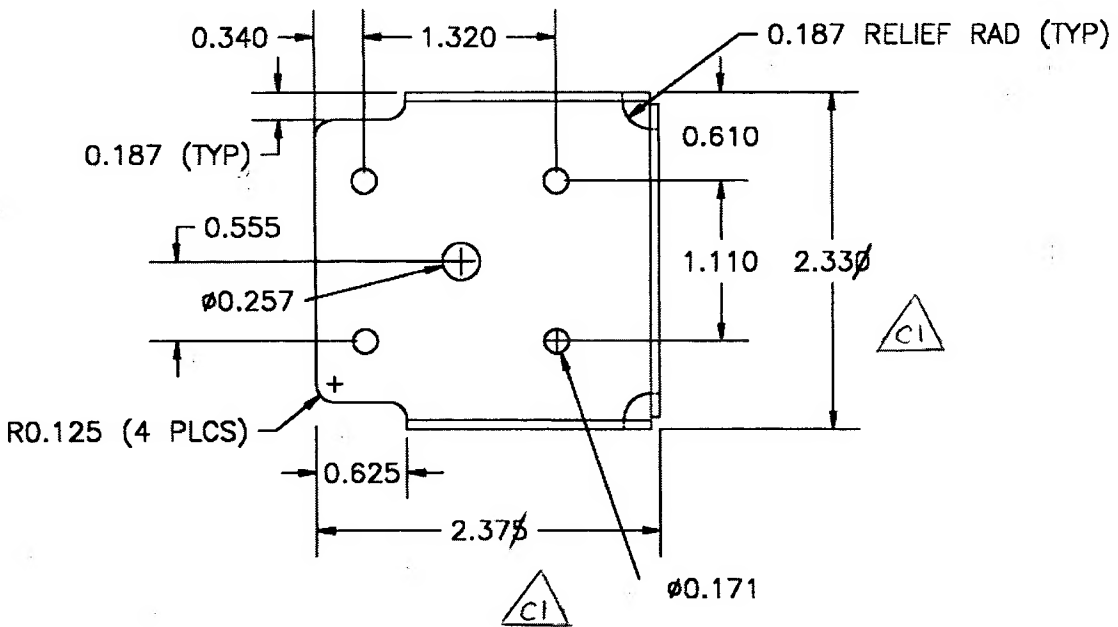
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
960626 Bus

| | | | | | |
|---------|-----------|----------|---------------------------------|--|--------------|
| DESIGN | J BRADLEY | DRAWN BY | K HAND | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | REV. C |
| CHECKED | BW | APPROVED | BW | DRAWING NO. D2143 | SHEET 1 OF 2 |
| DATE | 92:07:10 | TITLE | HINGE BRACKET | SCALE | |
| | B | 96.06.06 | ADD FLAT PATTERN | | |
| | C | 96.06.13 | MATERIAL WAS 2024-T3 .063 THICK | | |
| | CI | 04.06.15 | UPDATE DIMENSIONS | | |



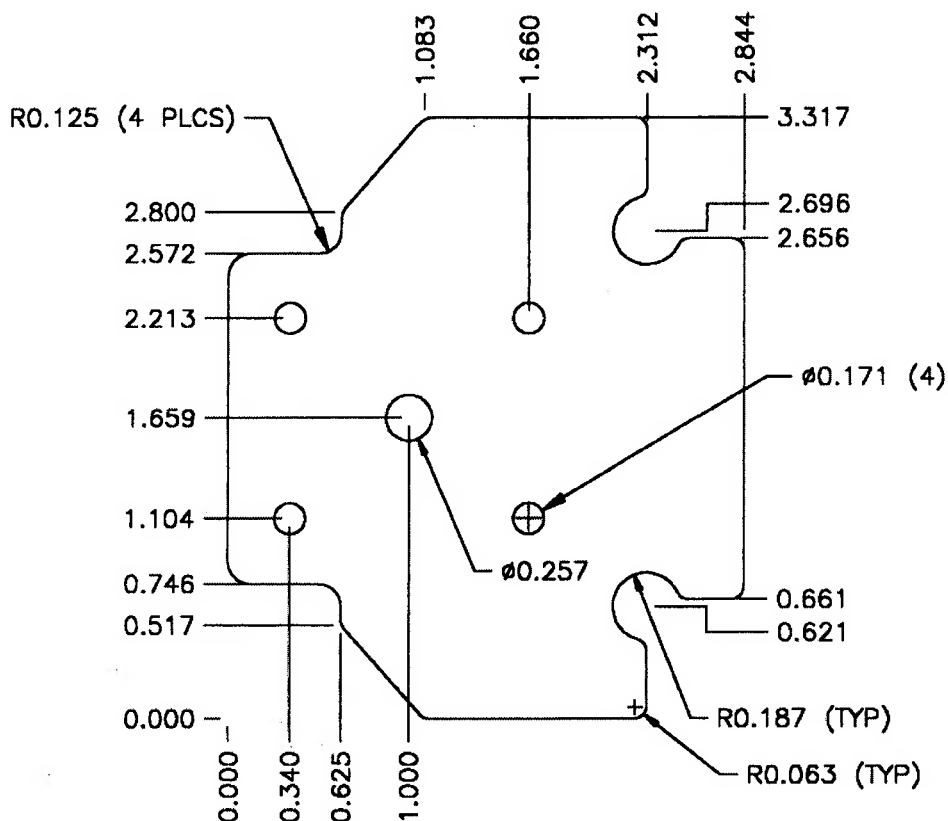
MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34464



| | | | |
|--------------------|----------------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| J BRADLEY | K HAND | VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. a |
| <i>[Signature]</i> | <i>[Signature]</i> | D2143 | SHEET 2 OF 2 |
| DATE | TITLE | | SCALE |
| 95:10:18 | HINGE BRACKET FLAT PATTERN | | 1:1 |

RELEASED
966620 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34464

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317